



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3121-141
Job Sheet 181848



Part No: D3121-141

Job Qty: 10 ea

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/9/18

Job Tracking No:

Due Date: 8/17/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E IPP Rev:Pick:A 04.02.18 New issue KJ/DS IPP Rev:B ECN 1060 07-11-12 DD verified by: EC
IPP Rev:C New Dimensions for Blank Size 08-07-23 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	8/17/18	8/17/18	0.00	0.00	Start Up Machining-1		Kt 2018-08-17
100	Bandsaw	10 pcs	8/17/18	8/17/18	0.00	1.13	Bandsaw1		Kt 2018-08-17
110	CNC Vertical Machining	10 pcs	8/17/18	8/17/18	0.47	19.61	HAAS1-3		Kt 2018-06-17
120	QC	10 pcs	8/17/18	8/17/18	0.00	0.00	QC2 Machining-1		Kt 2018-06-17
130	QC	10 pcs	8/17/18	8/17/18	0.00	0.00	QC8 Machining-1		Kt 18-08-22
140	Small Fab	10 pcs	8/17/18	8/17/18	0.00	0.28	Small Fab-2		DAS
150	QC	10 pcs	8/17/18	8/17/18	0.00	0.00	QC5		AUG 30 2018 68
160	Packaging	10 pcs	8/17/18	8/17/18	0.00	0.00	Packaging3-1		9-89
170	QC21-SA	10 Ea	8/17/18	8/17/18	0.00	0.00	QC21		DAS

Part Op 100 - Cut blanks: (1.250" x 2.000") 6.600" long
Descriptions: 110 - 1-Machine D3121-111 as per Folio FA361 and Dwg D3121Identify as D3121-111 3-Scribe batch number
140 - Assemble D3121-141 as per Dwg D3121.

5088987

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-B1.250X2.000	17-4 SS Bar 1.250 x 2.00	5.5000 ft (.55 ea)	90-Start up Operation	5088987
D3121-21	Bolt	10 Ea (1 ea)	140-Small Fab	5097200
D3121-241	Bearing Assembly	10 Ea (1 ea)	140-Small Fab	506810

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-B1.250X2.000	6	26	0
140-Small Fab	D3121-21	10	115	0
	D3121-241	10	10	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date : _____		OTY Effective : _____		MRB (QSI042) Approval																	
Descriptive Uart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S103321 Part: D3121-141 Job No: 181848 Serial No/Batch: S103321 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 08/17/18 Root Cause <table style="width:100%;"> <tr> <td style="width:50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-ve ☐ Operator ☐ Offset/Si ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>						Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-ve ☐ Operator ☐ Offset/Si ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐														
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OTHER : _____																					

DART AEROSPACE LTD		Work Order:	181848
Description: Bracket		Part Number:	D3121-111
Inspection Dwg: D3121 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.392	+0.002/-0.000	0.3932	✓		Kt-05	Verm.
0.75	+/-0.030	0.750	✓		" "	" "
0.375	+/-0.010	0.375	✓		" "	" "
2.14	+/-0.030	2.140	✓		" "	" "
1.96	+/-0.030	1.963	✓		" "	" "
0.280	+/-0.010	0.280	✓		" "	" "
3.330	+/-0.010	3.330	✓		" "	" "
3.630	+/-0.010	3.630	✓		" "	" "
R0.25	+/-0.030	0.250	✓		—	R.G
R0.375	+/-0.010	0.375	✓		" "	" "
Ø0.201	+/-0.010	0.201	✓		Kt-05	Verm.
0.100	+/-0.010	0.100	✓		" "	" "
4.580	+/-0.010	4.580	✓		" "	" "
6.18	+/-0.030	6.180	✓		" "	" "
5.89	+/-0.030	5.89	✓		" "	" "
0.080	+/-0.010	0.080	✓		" "	" "
0.300	+/-0.010	0.300	✓		" "	" "
30°	+/-0.1°	30°	✓		—	R.G
R0.25	+/-0.030	0.250	✓		—	R.G
0.130	+/-0.010	0.130	✓		Kt-05	Verm.
0.664	+/-0.010	0.664	✓		" "	" "
0.381	+/-0.010	0.380	✓		" "	" "
0.201	+/-0.010	0.201	✓		" "	" "
0.400	+/-0.010	0.400	✓		" "	" "
0.580	+/-0.010	0.580	✓		" "	" "
100°	+/-0.1°	100°	✓		" "	" "
0.032	+0.000/-0.010	0.029	✓		Kt-04	millimetre.

Measured by: Kt	Audited by: DAS 20 9-89	Preliminary Approval:
Date: 18-08-16	Date: 18-08-22	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.12	New Issue P/O D3121-141	KJ/RF	
B	04.05.05	Dimensions changed/re-arranged per Dwg revision	KJ/JLM	
C	06.06.14	Dwg Rev. updated	KJ/JLM	
D	08.01.16	Dimensions updated per Dwg Rev. E	KJ/EC/DD	
E	08.05.28	Tolerance revised for Ø0.201 dimension	KJ/DD	
F	13.10.22	Tolerance revised for Ø0.201 dimension	KJ	

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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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